

Work Order ID 54311-1

December 7, 2009 3:08:45 PM



Page 1

Item ID: D3774-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Seat Bottom, LH/RH

Start Date: 07/12/2009 Start Qty: 20.00

Required Date: 21/12/2009 Req'd Qty: 20.00



Cust Item ID:

Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date: 09-12-7

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3774

Rev B

100

0.00



HAND FINISHING THERMOFORMING

Thermoform

Memo

0.00

Thermoforming Machine

Set up machine program D3774-1 □ Set up clamping frame as per folio

OK 10/01/08

110

0.00



HAND FINISHING THERMOFORMING

Thermoform

Memo

0.00

Thermoforming Machine

Cut Blanks

OK 10/01/08
x11

120

0.00



THERMOFORMING MACHINE

Thermoform

Memo

0.00

Thermoforming Machine

Thermoform as per Dwg. D3774-1 and Folio □ Dwg. Rev.

B. □ Folio Rev. A.

OK 10/01/08
(x11)

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Work Order ID 54311

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Page 2

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Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

OK 10/01/09
(X 11)

140

HAND FINISHING THERMOFORMING

0.00



Thermoform

Memo

0.00

Thermoforming Machine

Trim to Finished Dimensions

★ SEE W/D
CHG, OVER

OK 10/01/09
(X 11)

150

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

1) Check dimensions to ensure conformity to drawing tolerances.

OK 10/01/09
(X 11)

W/O: 54311		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
10.01.11	140	DRILL ϕ 0.750 TYP ZPL 1 PER MARKED-UP DWG ATTACHED	ph	10/01/11		UP 10.01.11 per QSI 042	S 10/01/11

Part No: D3774-1 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Work Order ID 54311

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Item ID: D3774-1

Accept



Setup Start



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Stop



Item Name: Seat Bottom, LH/RH

Start Date: 07/12/2009 Start Qty: 20.00



Cust Item ID:

Required Date: 21/12/2009 Req'd Qty: 20.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

2> 8/10/12

(xLL)

φ

170

Identify as per dwg & Stock Location:

0.00



Packaging

Memo

0.00

Packaging

SP

10-1-12

102

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/01/12

MF 10-01-12

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NOTE: Date & initial all entries

Picklist Print

December 7, 2009 3:08:50 PM

Page 1

Work Order ID: 54311



Parent Item: D3774-1



Parent Item Name: Seat Bottom, LH/RH

Start Date: 07/12/2009

Required Date: 21/12/2009

Comments:

Start Qty: 20.00

Required Qty: 20.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

MLEXS.125-F60029-04

Purchased

No

110

sf

2,011.175

213.3400



GE PLASTICS LEXAN SHEET

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

2011.175198

103106

1.6765

105330

47.8767

109455

40.5717

111710

329.893632

112585

1591.15667

220.6 sq ft 10/01/08 wh

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 54311
Description: Seat Bottom		Part Number: D3774-1
Inspection Dwg: D3774	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: <i>W. Hays</i>	Date: 10/01/11
-----------------------------	----------------

TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.3	+/-0.100	1.3094				
33.9	+/-0.100	33.8754				
17.4	+/-0.100	17.54				
0.085	Min	0.0884				
0.100	Min	0.1154				
0.100	Min	0.1114				
0.100	Min	0.1124				
0.100	Min	0.1104				

Measured by: <i>W. Hays</i>	Date: 10/01/11
Audited by: <i>BP</i>	Date: 10/01/11
Prototype Approval:	Date:

Rev	Date	Change	Revised by	Approved
A	08.09.04	New Issue	KJ/DL	<i>AS</i>

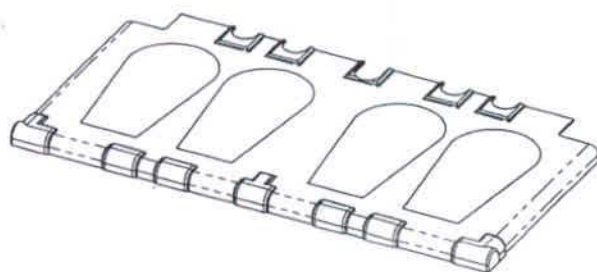
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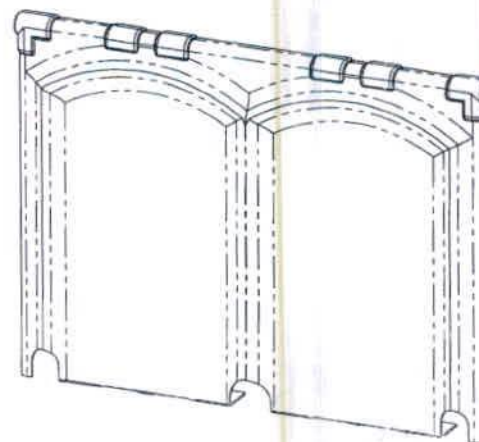
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NOTE: Date & initial all entries



D3774-1 SEAT BOTTOM



D3774-3 SEAT BACK

RELEASED
08-08-11/11

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 54311
REL 09-12-7

B	UPDATE CUTOUT DIMENSIONS (ZN D4-2, D6-2, C4-3, C7-3); UPDATE MINIMUM THICKNESS (ZN A5-2, A5-3); ADD HOLES ON D3774-3 (ZN B6-3) REASON: MANUFACTURING CAPABILITIES	PH	08.07.25
A	NEW ISSUE	HS	08.06.23
REV.	DESCRIPTION	BY	DATE
DESIGN	HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	PH		
CHECKED	PH	DRAWING NO.	REV. B
MFG. APPR.	PH	D3774	SHEET 1 OF 3
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	SEAT	NTS
DATE	08.07.25	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

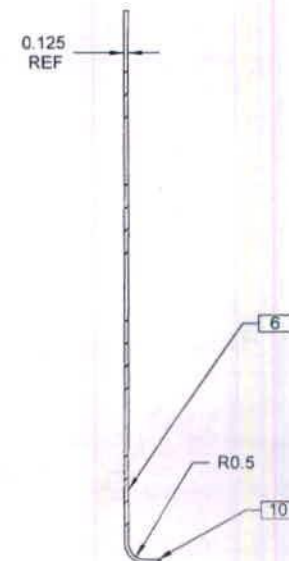
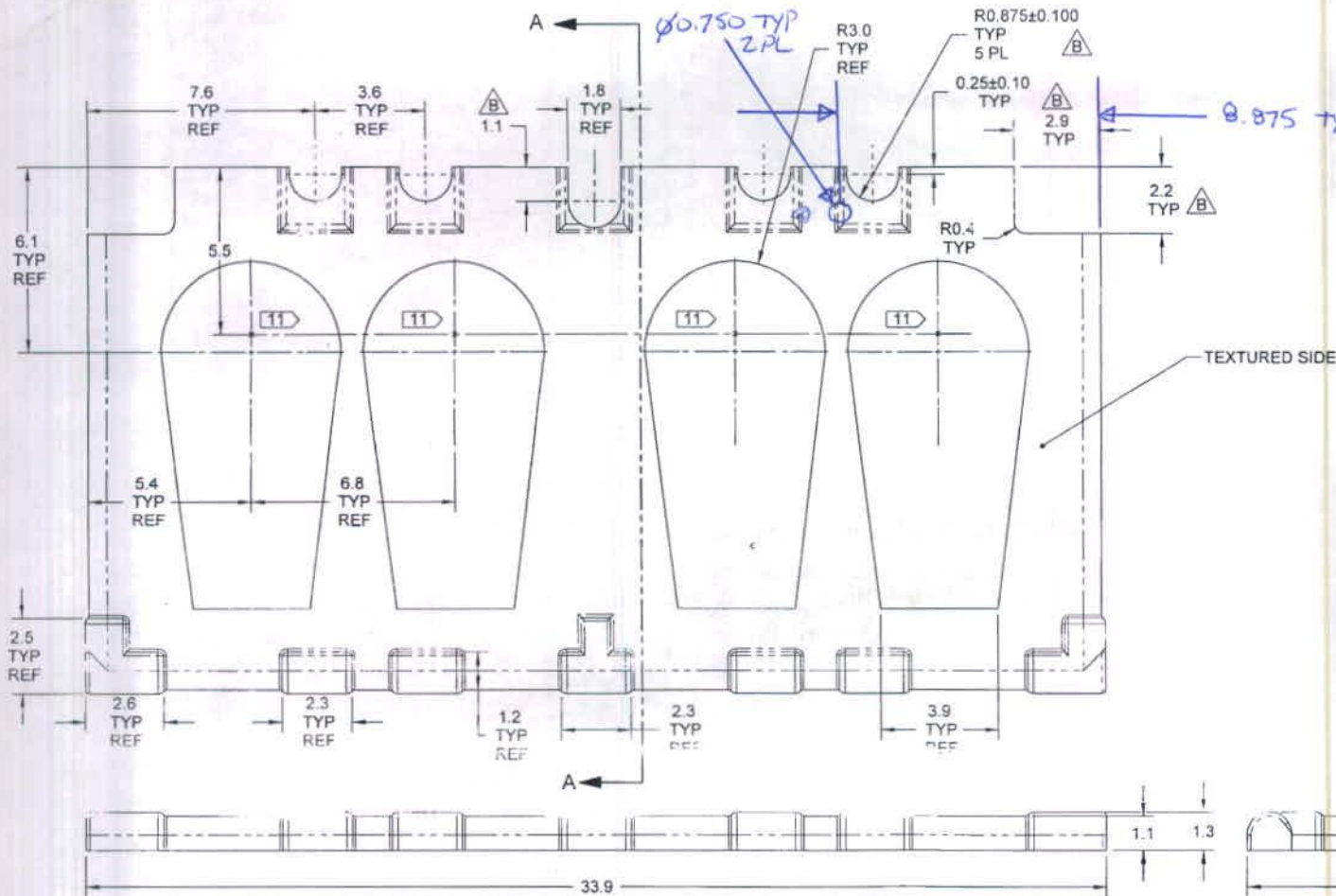
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SECTION A-A

D3774-1 SEAT BOTTOM

NOTES:
 MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE) 0.125" THICK TEXTURED SIDE UP (REF. DART SPEC MLEXS.125-F60029-04)
 FINISH: NONE
 TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 UNITS: INCHES UNLESS OTHERWISE NOTED
 BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 IDENTIFICATION: IDENTIFY WITH DART P/N "D3774-1" USING VIBRATING STYLUS
 WEIGHT: 2.93 lbs
 PART TO BE PRODUCED FROM MOLD DT9022 AND PER DART QSI 022
 OVERALL DIMENSIONS GIVEN ONLY FOR FURTHER INFORMATION REFER TO MOLD DT9022
) MINIMUM MATERIAL THICKNESS AFTER FORMING ON FLANGES (WITHIN 2.0 FROM EDGES) IS 0.085
) MINIMUM MATERIAL THICKNESS AFTER FORMING AT THESE POINTS IS 0.100

DESIGN	HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	HS		
CHECKED	HS	DRAWING NO.	REV. B
MFG. APPR.	HS	D3774	SHEET 2 OF 3
APPROVED	HS	TITLE	SCALE
DE APPR.	HS	SEAT	NTS
DATE	08.07.25	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

RELEASED
 08-06-11/15

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